

Work Order ID 139829

Wednesday, December 09, 2015 12:35:14 P

139829

Ship Dec 14

Page 1

Item ID: D3935-2

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Pylon Wall

Start Date: 12/9/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/11/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: MLJDate: DEC 09 2015

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3935

B

100

0.00

100

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3935

Dwg Rev: BProg Rev: B

2- Deburr if necessary

0.01

①

DEC 15/12/14

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

①

DEC 15/12/14

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
		OTHER : ☐							

Work Order ID 139829***139829***

Page 2

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N900040100

Setup Start

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Revision ID:

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Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

DEC 14 2015

DAS
9

9-89

130

Identify as per dwg & Stock Location: _____

0.00

130

Packaging

Memo

0.00

Packaging

IX DAS
28
9-89

DEC 14 2015

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MCJ

DEC 14 2015

MCJ DEC 14 2015

DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
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				OTHER :							

Picklist Print

Wednesday, December 09, 2015 12:35:18 PM

Page 1 /

Work Order ID: 139829

139829

Parent Item: D3935-2

D3935-2

Parent Item Name: Pylon Wall

Start Date: 12/9/2015

Required Date: 12/11/2015

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased			No	100	sf	1,742.000	8.69	10.22353			

MI FXS 125-F60029-04

GE PLASTICS LEXAN SHEET

12/12/14

Location

MAT018

m133111

Loc Qty

1742

1742

Loc Code

12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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		OTHER : ☐							

DART AEROSPACE LTD		Work Order: 139829
Description: Pylon Wall Protector, RH		Part Number: D3935-2
Inspection Dwg: D3935	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.50	+/-0.030	3.50	/		Viper-2	
9.00	+/-0.030	9.00	/		Tape	
14.70	+/-0.030	14.70	/			
16.20	+/-0.030	16.20	/			
33.40	+/-0.030	33.40	/			
34.25	+/-0.030	34.25	/			
34.60	+/-0.030	34.60	/			
34.72	+/-0.030	34.72	/			
22.85	+/-0.030	22.85	/			
19.15	+/-0.030	19.15	/			
35.39	+/-0.030	35.39	/			
8.05	+/-0.030	8.05	/			
15.05	+/-0.030	15.05	/			
19.00	+/-0.030	19.00	/			
19.25	+/-0.030	19.25	/			
20.25	+/-0.030	20.25	/			
23.25	+/-0.030	23.25	/			
24.35	+/-0.030	24.35	/			
29.25	+/-0.030	29.25	/			
32.75	+/-0.030	32.75	/			
0125	+/-0.010	.125	/			

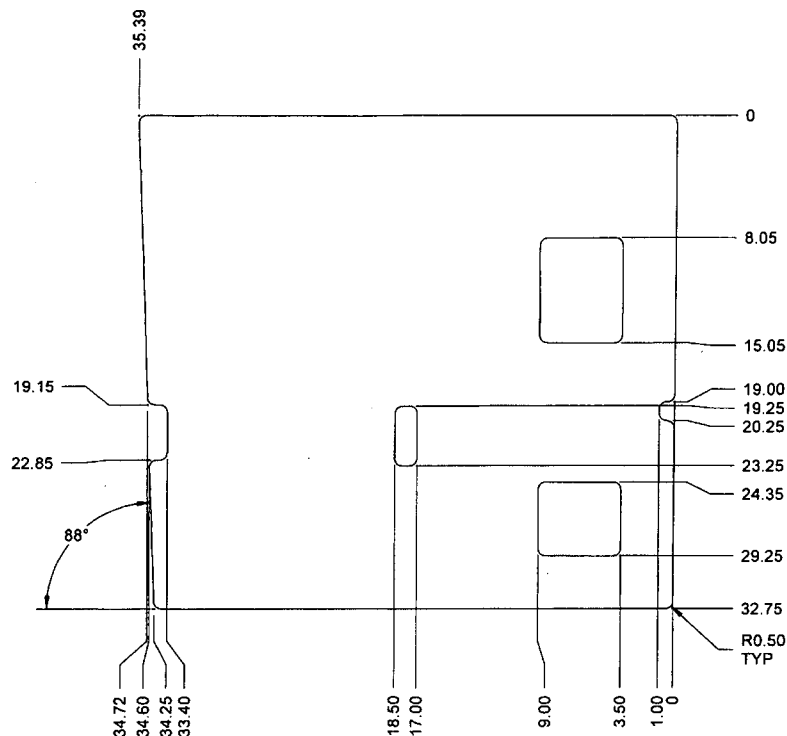
Measured by: <i>DL</i>	Audited by: <i>DAS</i>	Preliminary Approval:	N/A
Date: 15/12/14	Date: DEC 14 2015	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.06.22	New Issue	KJ	
B	10.08.18	Dwg Rev updated	KJ	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 139829-ML5

15-12-09

0.125
REF



RELEASED
2009-10-22
MD

D3935-1 PYLON WALL PROTECTOR, LH
(TEXTURED SIDE SHOWN)

NOTES:

- 1) MATERIAL: F60029-GY3778 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125 THICK
REF DART SPEC MLEXS: 125-F60029-04
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3935-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 5.79 lbs
- 8) CHECK PER TEMPLATE DT8922

B	ADD -3, -4 (SHEET 3, 4)	HS	09.08.19
A	NEW ISSUE	HS	09.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.08.19		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3935	REV. B SHEET 1 OF 4
TITLE PYLON PROTECTOR	SCALE NTS
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